

Work Order ID 66508

Thursday, February 17, 2011 10:56:07 AM

Page 1

Item ID: D4330-3
Revision ID: PRELIM
Item Name: Airframe Bracket

**PRELIMINARY
ISSUE**

Start Date: 2/17/2011 Start Qty: 2.00
Required Date: 2/18/2011 Req'd Qty: 2.00



Setup Start



Stop



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: NLF Date: 11-02-17 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4330	PAT PA2								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
6261, 656	Dwg Rev: <u>PA1</u>								
	Prog Rev: <u>PA1</u>								
	2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

B 11-2-17

3

B 11-2-17

-inspector to PA2

Dwg only

8 wheels

(x3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 66508

Thursday, February 17, 2011 10:56:07 AM

Page 2

Item ID: D4330-3 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Airframe Bracket
Start Date: 2/17/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 2/18/2011 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.00 0.00				(2)	(2)		PR →
			SB	11/02/22					
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
				inspected to PAR Dry only 8/10/22					(72)
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
						2	0	11/02/22	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4330-3 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: [Signature] Date: 11-02-22

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>66508</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/01/22	130	1 part scrap try out / prelim R.C Process	<u>[Signature]</u>	Scrap & destroy	<u>ES</u> 11/02/22	<u>S</u> 11/02/22	<u>[Signature]</u>	<u>[Signature]</u> 11-02-22

NOTE: Date & initial all entries

Work Order ID 66508

Thursday, February 17, 2011 10:56:07 AM

Page 3

Item ID: D4330-3

Accept

Revision ID: PRELIM

Item Name: Airframe Bracket

Setup Start

Stop

Start Date: 2/17/2011 Start Qty: 2.00

Required Date: 2/18/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				2	BR	11-02-22	
170  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

charge
to
RD1370868
PS10-222
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, February 17, 2011 10:56:04 AM

Page 1

Work Order ID: 66508



Parent Item: D4330-3



Parent Item Name: Airframe Bracket

Start Date: 2/17/2011

Required Date: 2/18/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.02.17 new issue DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050		Purchased	No			100	sf	198.3900	0.1402	0.295158			



6061-T6 .050 Sheet



1311-2-17

Location

Loc Qty

Loc Code

MAT

166.8

114799

38.8

114993

128

MAT21

31.59

113216

31.59

113214

3

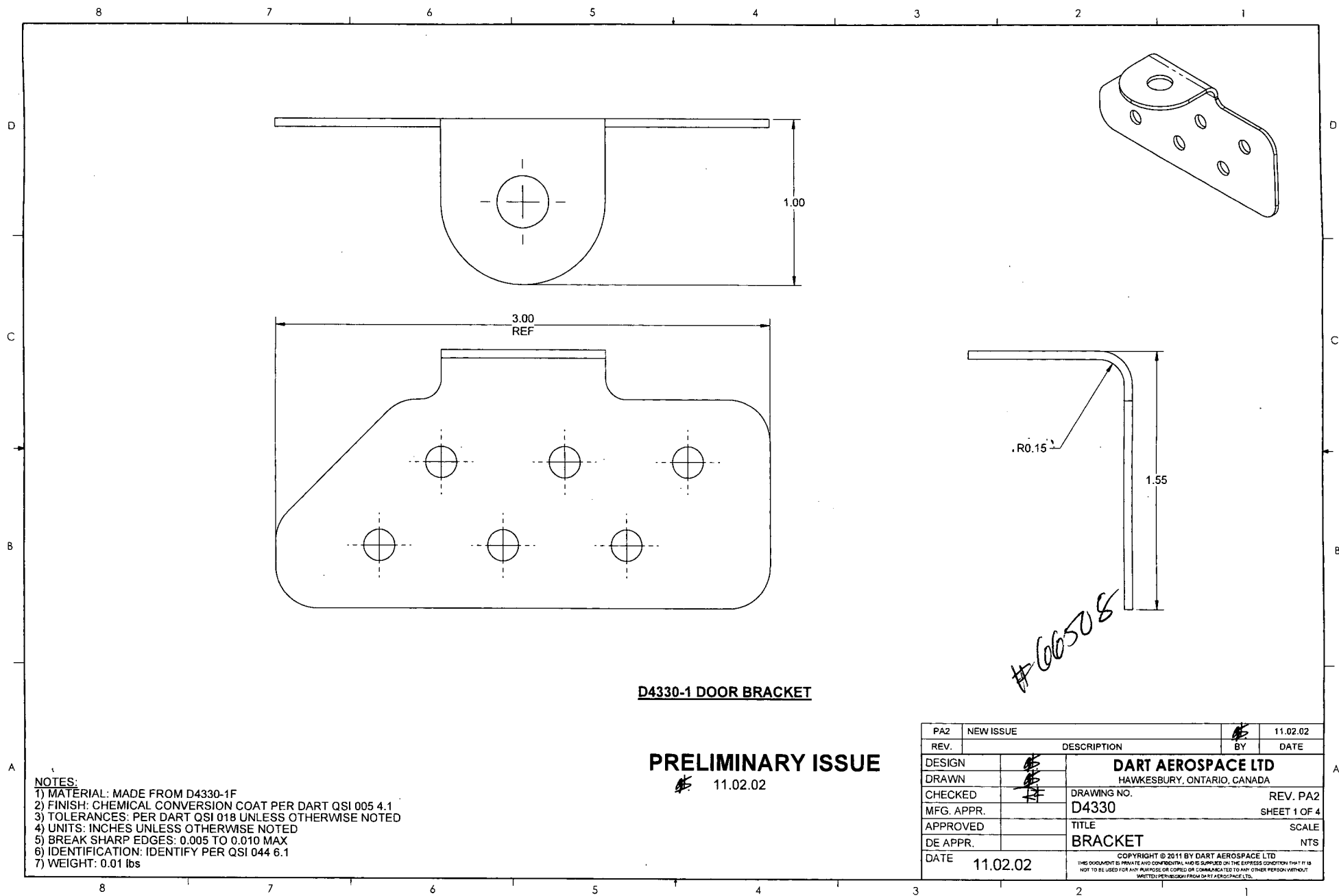
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4330-1 DOOR BRACKET

PRELIMINARY ISSUE

11.02.02

NOTES:

- 1) MATERIAL: MADE FROM D4330-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

PA2	NEW ISSUE		11.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.02		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4330** REV. PA2
SHEET 1 OF 4
TITLE **BRACKET** SCALE NTS

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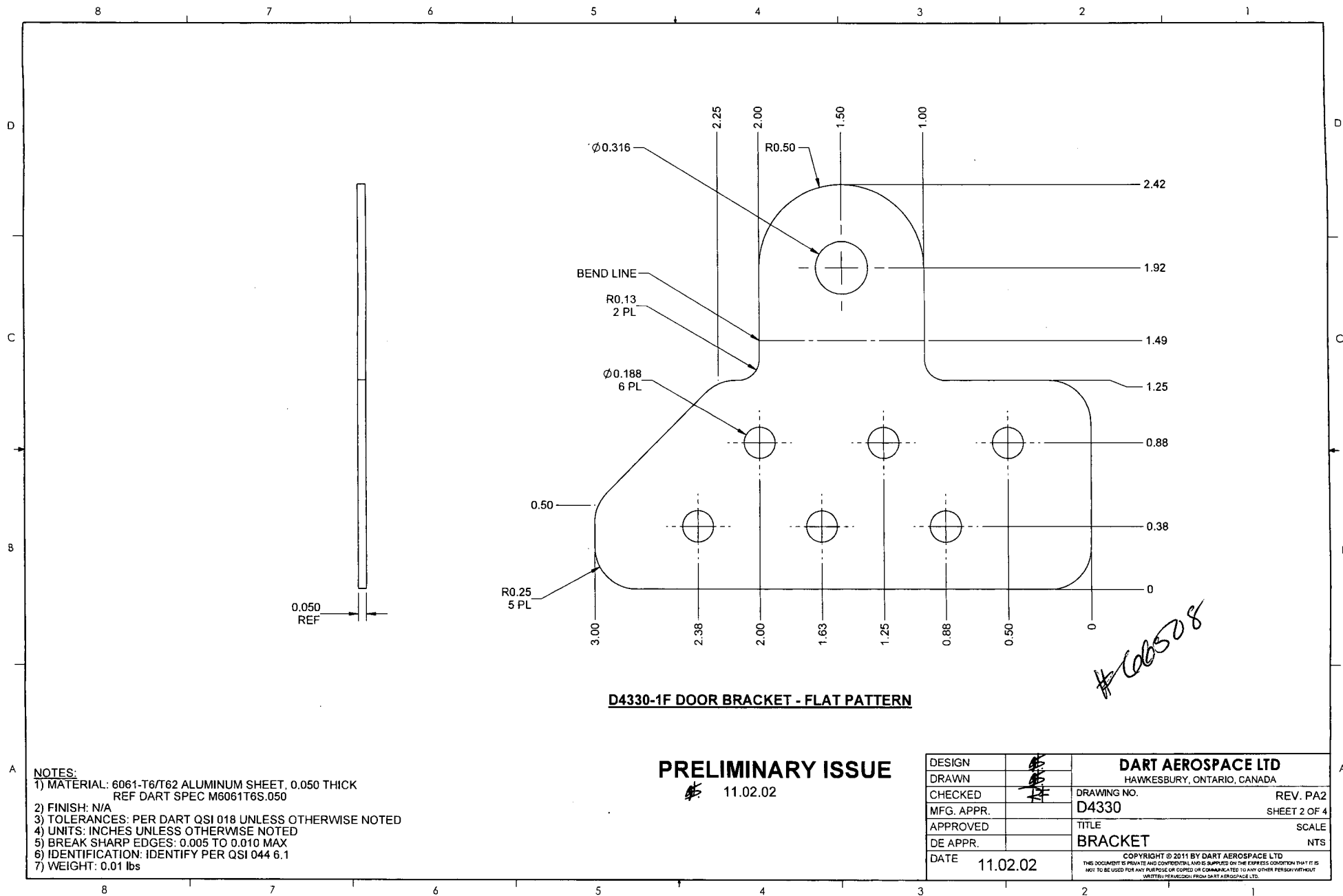
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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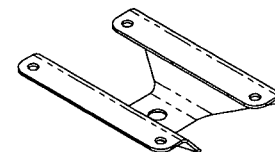
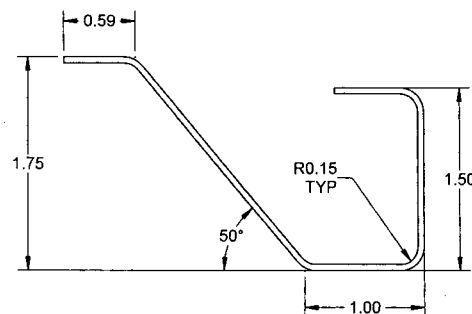
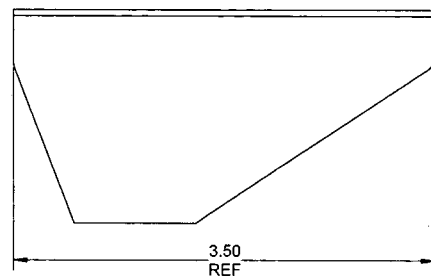
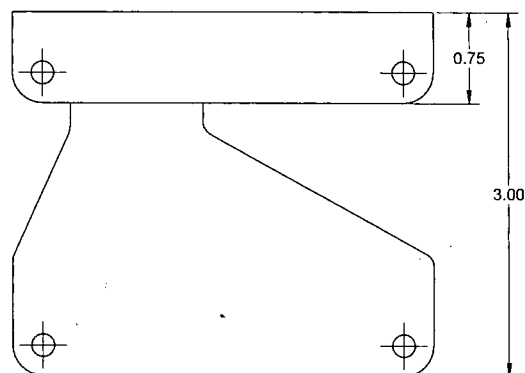
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4330-3 AIRFRAME BRACKET

PRELIMINARY ISSUE

11.02.02

NOTES:

- 1) MATERIAL: MADE FROM D4330-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D4330	SHEET 3 OF 4
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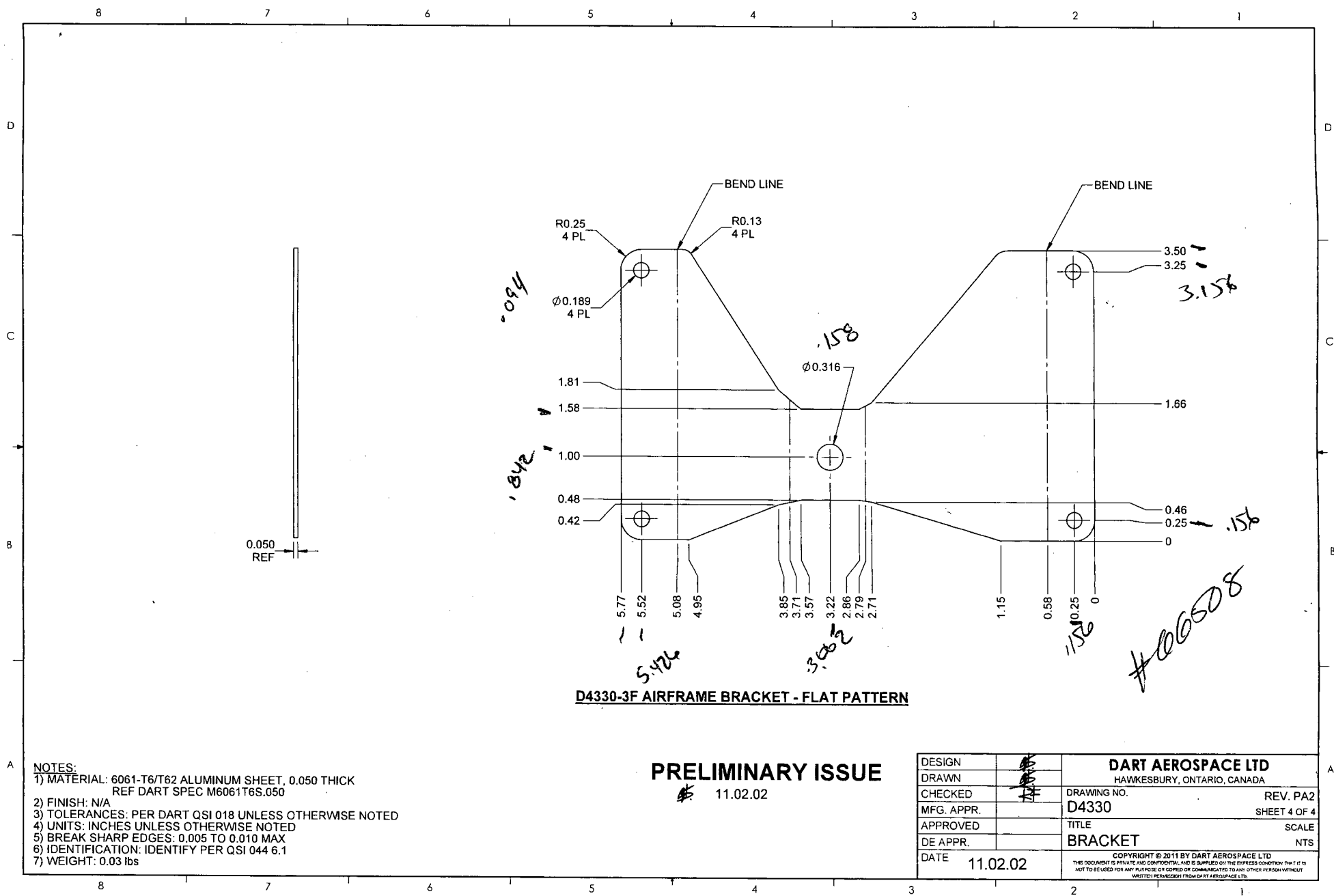
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



- NOTES:
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.050 THICK
REF DART SPEC M6061T6S.050
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.03 lbs

PRELIMINARY ISSUE

11.02.02

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